

Date: 5/25/2007 8:37:41 AM  
User: Kevin Johnston

## Process Sheet

Split  
815 07/06/05

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32661-1  
Estimate Number : 12811  
P.O. Number :  
This Issue : 5/25/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : SMALL / MED FAB  
Previous Run : 32003  
Written By : 07.05.28  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-03.26 ec

Drawing Name : BRACKET

Part Number : D35921  
Drawing Number : D3592-REVA  
Project Number : N/A  
Drawing Revision : REVA  
Material :  
Due Date : 6/10/2007

Qty: 125 Um: Each

UNDER REVIEW

07-06-04

OK 07.06.04

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total: 17.5140 sf(s)

6061-T6 .125 Sheet

Batch: M104366M104366

\*\*\*Grain must be Along 4.63\*\*\*

ml 070530ml 070604

(125)

(125)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: AProg Rev: A

2-Deburr if necessary

ml 070604ml 070530

(125)

(125)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

ml 070604  
ml 070530

(125)

(125)

(P10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS

07/06/05

125

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

SB 07/06/12

(42)





| W/O:     |      | WORK ORDER CHANGES  |    |          |     |                                     |                                |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------------|
| DATE     | STEP | PROCEDURE CHANGE  | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector       |
| 07.06.15 | 2    | REPROGRAM TO REV.B TO ADD TOLLING HOLES.<br>SEE ATTACHED DS EMAIL FOR OK ON TOLLING HOLES |    |          |     | <i>[Signature]</i><br>07.06.15      |                                |
| 07.06.15 | 5    | Split w/o   |    |          |     |                                     |                                |
| 07.06.15 | 5    | Split w/o   | 85 | 07.06.15 | 85  | <i>[Signature]</i><br>07.06.15      | <i>[Signature]</i><br>07.06.15 |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                                 |                                       |   |                                |                                |                                       |                                |
|----------|------|--|---------------------------------------|---|--------------------------------|--------------------------------|---------------------------------------|--------------------------------|
| DATE     | STEP | Description of NC<br>Section A                                   | Corrective Action<br>Section B        |   |                                | Verification<br>Section C      | Approval<br>Chief Eng                 | Approval<br>QC Inspector       |
|          |      |  | Initial<br>Chief Eng                  | Action Description<br>Chief Eng   | Sign &<br>Date                 |                                |                                       |                                |
| 07.06.04 | 2.0  | 125 parts scrap. Parts needed extra holes for the benching tool. | <i>[Signature]</i><br>07.06.04<br>p/r | Scrap parts, and replace to Rev. B, under Preliminary Issue. See E-mail | <i>[Signature]</i><br>07.06.04 | <i>[Signature]</i><br>07.06.04 | <i>[Signature]</i><br>07.06.04<br>p/r | <i>[Signature]</i><br>07.06.04 |
|          |      |  | Q51642                                | Scrap: destroy parts  | <i>[Signature]</i><br>07.06.04 | SP<br>07.06.04                 | Q51642                                | 07.06.04                       |
|          |      |  |                                       |   |                                |                                |                                       |                                |
|          |      |  |                                       |   |                                |                                |                                       |                                |

NOTE: Date & initial all entries



25/2007 8:37:41 AM

anston

## Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Jan 12*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W.A.

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED 07.06.05

DATE

*21.02.10*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.06.13*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07.06.13*





## Jason Murdoch

---

**From:** Daniel Campbell [dcampbell@dartaero.com]  
**Sent:** Thursday, May 31, 2007 9:41 AM  
**To:** 'Beckett, Bill'; Bedford, Sue; 'Bell, Christopher'; Campbell, Daniel; 'Charbonneau, Eric'; 'Elsiger, Leanne'; 'Fuentes, Roberto'; Golden, Brigitte; 'Johnston, Kim'; 'Lacelle, Linda'; mbellavance@dartaero.com; 'Menard, Jean-Luc'; 'Murdoch, Jason'; phum@dartaero.com; 'Provencal, Chris'; 'Sheldon, Susanne'; 'Shepherd, David'; 'Stow, Dan'; 'Trepanier, Dale'; Willems, Sian  
**Subject:** D3592-1 REV. A – UNDER REVIEW –

FYI,

D3592-1 is under review.

Essentially, the revision will consist of adding two 0.128 dia. tooling holes to assist in bending the part.

Bluefiles, CHG #, and in-stock items are not affected by this change.

Estimates for the D3592-1 should be placed under review.

Production is aware of this change and current production has already been modified.

**Daniel Campbell**  
**Co-op Student**

**DART** aerospace Ltd.

Tel: 613-632-5200 Ext. 241

Fax: 613-632-9311

E-mail: [dcampbell@dartaero.com](mailto:dcampbell@dartaero.com)

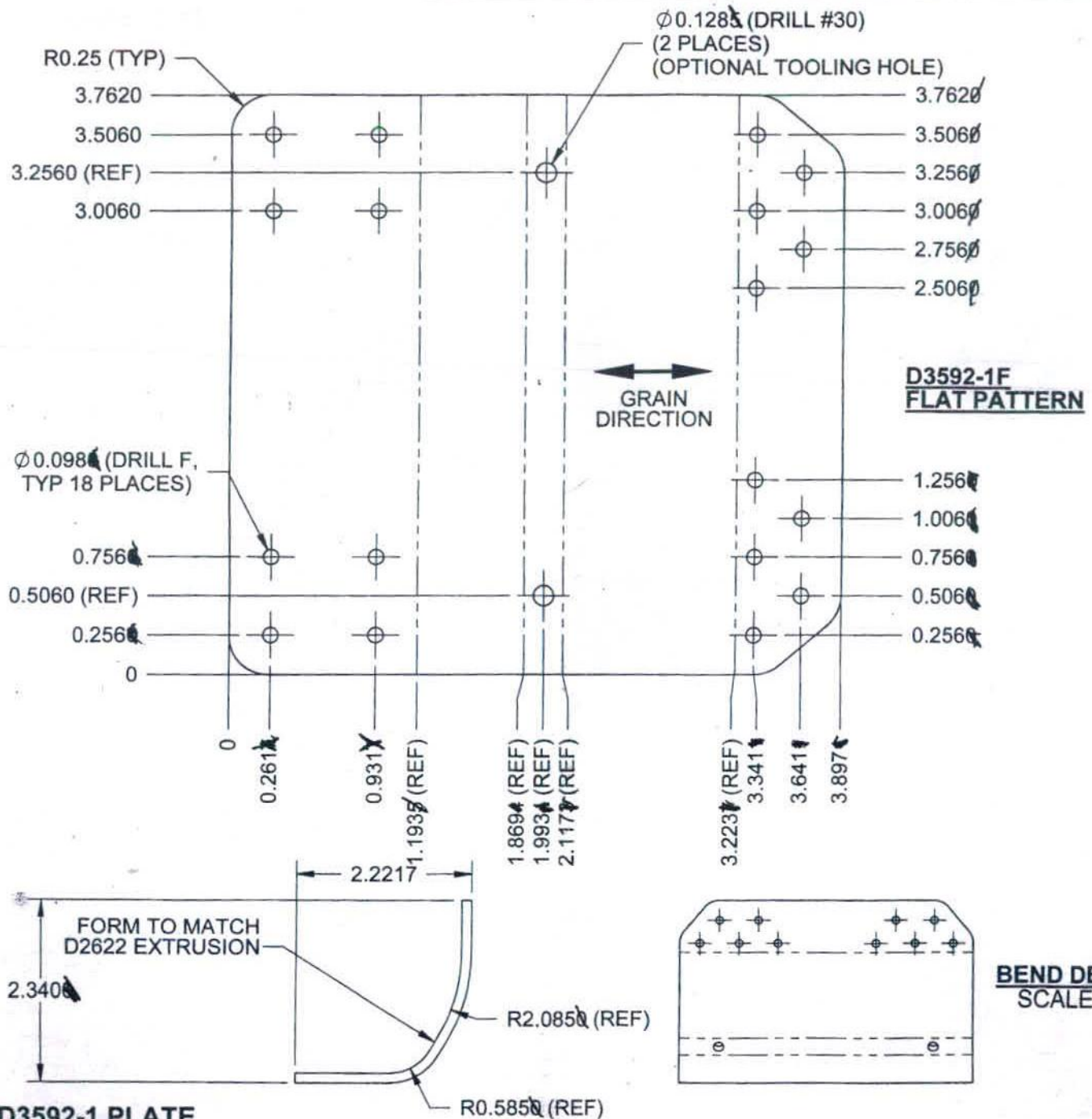
Web: [www.dartaero.com](http://www.dartaero.com)





**PRELIMINARY ISSUE**  
 07.06.04

|                  |                |  |                        |
|------------------|----------------|--|------------------------|
| DESIGN<br>90     | DRAWN BY<br>JC | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED          | APPROVED       | DRAWING NO.<br>D3592                                     | REV. A<br>SHEET 1 OF 1 |
| DATE<br>07.01.15 | TITLE<br>PLATE |  | SCALE<br>1:1           |
| A                | 07.01.15       | NEW ISSUE  |                        |
| B                | 07.05.31       | TOOLING HOLES ADDED                                      |                        |



### D3592-1 PLATE

#### NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





AEROSPACE LTD

Work Order: 32661

Description: Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

| Inspection Sheet<br>Drawing Dimension | Tolerance      | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|----------------|---------------------|--------|--------|-------------------------|----------|
| A $\phi 0.128$                        | $+0.005-0.001$ | 0.129               | ✓      |        | VERN                    |          |
| B $\phi 0.098$                        | $+0.004-0.001$ | 0.099               | ✓      |        | VERN                    |          |
| C 0.506                               | $+/-0.010$     | 0.510               | ✓      |        | VERN                    |          |
| D 0.256                               | $+/-0.010$     | 0.260               | ✓      |        | VERN                    |          |
| E 0.756                               | $+/-0.010$     | 0.760               | ✓      |        | VERN                    |          |
| F 3.256                               | $+/-0.010$     | 3.260               | ✓      |        | VERN                    |          |
| G 0.261                               | $+/-0.010$     | 0.265               | ✓      |        | VERN                    |          |
| H 1.993                               | $+/-0.010$     | 1.995               | ✓      |        | VERN                    |          |
| I 3.341                               | $+/-0.010$     | 3.346               | ✓      |        | VERN                    |          |
| J 3.641                               | $+/-0.010$     | 3.645               | ✓      |        | VERN                    |          |
| K 3.897                               | $+/-0.010$     | 3.902               | ✓      |        | VERN                    |          |
| L 3.762                               | $+/-0.010$     | 3.766               | ✓      |        | VERN                    |          |
| M                                     |                |                     |        |        |                         |          |
| N                                     |                |                     |        |        |                         |          |
| O                                     |                |                     |        |        |                         |          |
| P                                     |                |                     |        |        |                         |          |
| Q                                     |                |                     |        |        |                         |          |
| R                                     |                |                     |        |        |                         |          |
| S                                     |                |                     |        |        |                         |          |
| T                                     |                |                     |        |        |                         |          |
| U                                     |                |                     |        |        |                         |          |
| V                                     |                |                     |        |        |                         |          |
| W                                     |                |                     |        |        |                         |          |
| X                                     |                |                     |        |        |                         |          |
| Y                                     |                |                     |        |        |                         |          |

Measured by: *mm. ml*  
Date: 07/04/04Audited by: *MS*  
Date: 07/04/04Prototype Approval: N/A  
Date: N/A

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
|     |      | New Issue | KJ/RF      |          |

*JD*

